

Work Order ID 86867

86867

Page 1

July-06-12 3:18:23 PM

Item ID: D2970-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Wearplate
Start Date: 7/06/12 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 8/10/12 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: *[Signature]* Date: 12-07-10 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2970	Rev A					(4)			
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D2970 Dwg Rev: <u>A</u> Prog Rev: <u>A</u> 2-								
1010.046	Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

12-7-19

12-7-19

Smb
12-7-19
DAS 16
9-02
12/07/19

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	NC BRAKE	0.00							
130									
Brake NC	Memo	0.00							
Brake NC	Deburr and form on brake using DT8178 and DT8261as per Dwg D2970								
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							
Quality Control									
150	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
150									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 11:50 OVEN TEMPERATURE:								
	FINISH TIME: 12:20								

W 12/27/9

3200F

12:20

8/12/07/24

CE

MT 12/07/24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Accept

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Revision ID:

Stop ***NS2***

Item Name: Wearplate

Start Date: 7/06/12 Start Qty: 4.00

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Cust Item ID:

Required Date: 8/10/12 Req'd Qty: 4.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location <u>FD-1</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

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MLJ 12/07/25

ME
12-07-25

Dart Aerospace Ltd

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Picklist Print

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Page 1

Work Order ID: 86867

Parent Item: D2970-3

Parent Item Name: Wearplate

Start Date: 7/06/12

Required Date: 8/10/12

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: B01.06.07Added Material and Tool numberSM/EC
IPP C 08.09.03 Waterjet EC verified: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S19GA 1010/1025 SHEET .040		Purchased	No			100	sf	0.0000	1.25	5.263158			

B12-7-19

121780

(4)

Dart Aerospace Ltd

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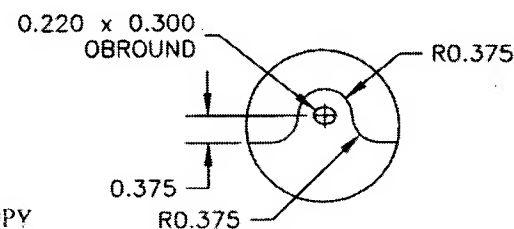
NOTE: Date & initial all entries

DART

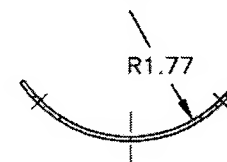


DESIGN	DRAWN BY	DRAWING NO.	REV. A
RF	RF	D2970	SHEET 1 OF 1
CHECKED	APPROVED	TITLE	SCALE
<i>[Signature]</i>	<i>[Signature]</i>	WEARPLATE	1:10
DATE			
00.03.10			
A	00.03.10	NEW ISSUE	

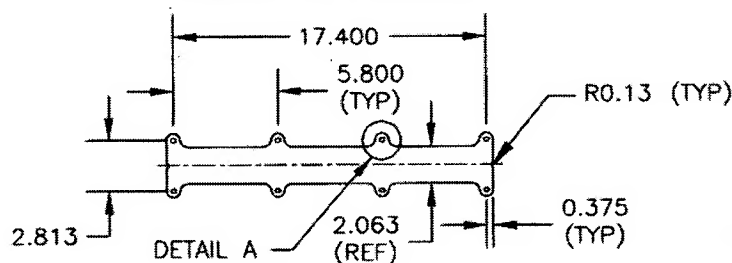
DETAIL A
SCALE 2:5



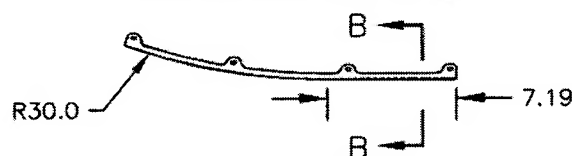
SECTION B-B
SCALE 2:5



D2970-1 FLAT PATTERN

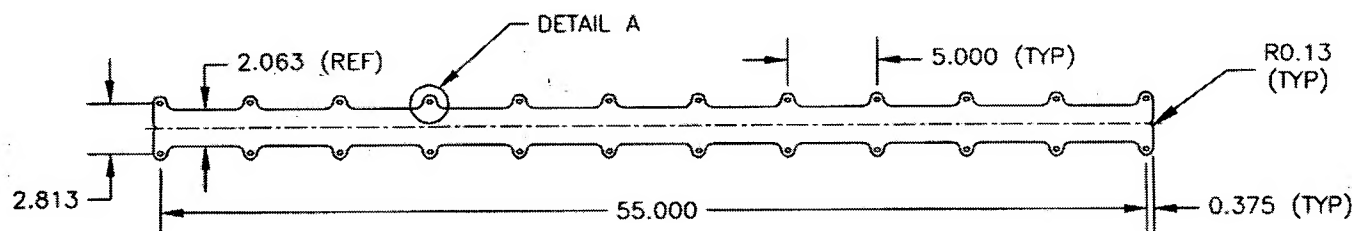


D2970-1 BENDING DETAIL

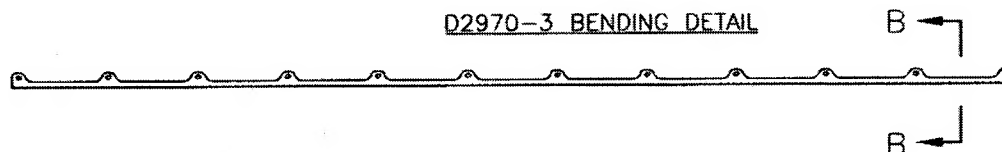


SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *86867*
12-07-10

D2970-3 FLAT PATTERN



D2970-3 BENDING DETAIL



BREAK ALL SHARP EDGES 0.010 TO 0.020
MATERIAL: AISI 1010-1025 OR ASTM A36/A366 SERIES STEEL
20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

RELEASED
00.05.11

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